

RG 104, 8NS-104-94-077
Box 1

8NS-104-94-077, Miscellaneous
Correspondence & Memos, 1897-1994

Report on Management Actions 10/8/57

REPORT ON MANAGEMENT ACTIONS PRESENTLY UNDERWAY
OR SCHEDULED FOR ACTION

OCT 8 1957

Bureau or Office		Date	
UNITED STATES MINT - DENVER, COLORADO - COINING DIV.		SEPTEMBER 30, 1957	
Action Number	Brief Title and Description of Surveys, Studies or Other Management Actions	Tentative Dates	
		Start	Finish
0-10	Balancing coin press capacity with rolling capacity. <u>Action Taken:</u> The installation and speeding up of the 9 coin presses received from the San Francisco Mint was completed during July. The new total of 29 presses was operated continuously during August and September, and provided a good test period for comparison with the same period the previous year when stamping equipment consisted of 22 presses. The increase from 22 presses to 29 presses is 31.8%. An increase in personnel of 25% was required to operate the 29 presses, but the increase in average daily production was 36.9%. The estimated annual savings in the stamping operation on a 2 - 8-hr. shift basis is \$1,000.00. Another important benefit is the better balance between rolling and stamping operations that has been obtained. Bronze rolling and stamping capacity are now in approximate balance, although bronze rolling could be increased somewhat on a 100% bronze program if ingot melting capacity was large enough to produce all the ingots that could be rolled. Stamping capacity is more than enough to handle any combination of bronze and nickel blanks or bronze and half dollar blanks that the rolling operation can produce. Stamping capacity still falls a little short of balancing rolling capacity on certain combinations of bronze, dime and quarter dollar blank production. Absolute balance of ingot melting, rolling, and stamping operations cannot be achieved because of variations in melting time, rolling time, and size of blanks for the various alloys and denominations. The monetary value of better balance is difficult to estimate. The increased stamping volume requires equal supporting volume in the other section. This should be reflected in lower unit costs of overhead items that do not increase in proportion to production. Monetary evaluation of this factor was not attempted at this time.	Jan. 1 1950	Jan. 1958

Increased Prod.
Inc. Personnel

REPORT ON MANAGEMENT ACTIONS PRESENTLY UNDERWAY
OR SCHEDULED FOR ACTION

Bureau or Office		Date	
U. S. MINT - DENVER, COLORADO		SEPTEMBER 30, 1957	
Action Number	Brief Title and Description of Surveys, Studies or Other Management Actions	Tentative Dates	
		Start	Finish
- 2 -			
1-1	X-ray gauging and automatic control of finished strip thickness. <u>Action Taken:</u> The X-ray gauge with control equipment is expected to arrive at the Denver Mint October 7, 1957. Installation work by the Mint mechanics and electricians will be pushed as fast as possible. Much preliminary work has already been done. The installation of this equipment must be accomplished without interfering with regular operation of the finish rolling mill to any extent. Completion of installation and test operation will probably be done on a weekend. The Industrial Gauges Company engineer is available on call when needed. It is expected that the installation will be completed about the third week in October.	8/1/51	Indef.
1-6	Erection of steel storage bins for coinage blanks. <u>Action Taken:</u> The situation remains as stated in Management Improvement report of June 30, 1957.	7/1/51	Indef.
5-24	Storage of 500,000,000 bronze blanks. <u>Action Taken:</u> The situation remains as stated in Management Improvement report of June 30, 1957.	9/30/55	Indef.
6-25	Increase blanking capacity. <u>Action Taken:</u> Two Bliss high-speed blanking presses were transferred from the San Francisco Mint to Denver. One of these has been placed in operation. Some mechanical changes, including substitution of the Denver clip chopper for the San Francisco clip chopper, had to be made. Installation of the second Bliss blanking press has not yet been made because the Mechanical Division has been fully occupied with higher priority work. The second Bliss press will replace a slower General Engineering Company Press.	6/30/56	Jan. 1957

REPORT ON MANAGEMENT ACTIONS PRESENTLY UNDERWAY
OR SCHEDULED FOR ACTION

Bureau or Office U. S. MINT - DENVER, COLORADO		COINING DIVISION	Date SEPTEMBER 30, 1957	
Action Number	Brief Title and Description of Surveys, Studies or Other Management Actions		Tentative Dates Start Finish	
	- 3 -			
	The blanking equipment now consists of 5 presses instead of 4. This improves the blanking operations very materially. The maintenance work can now be done without interfering with operations to the extent of making overtime work necessary. Also maintenance work often done on an overtime basis may now be done on regular time. Finish rolling operations also benefit because blanking capacity is sufficient at all times to prevent build up of finished coils in the storage area to the point of jamming. Further improvement will be realized when the second Bliss press replaces one of the General Engineering Company presses. Estimated annual monetary savings in the blanking operations and maintenance of equipment is \$3,000.00.			
6-26	Improve handling of cut blanks between Process Weigh and the Annealing and Cleaning Section. <u>Action Taken:</u> Cut blanks from Process Weigh to Annealing and Cleaning Section are handled in 10,000 ounce capacity tote boxes which can be lifted by crane and dumped directly into the annealing furnace charging drum. Formerly this material was loaded on hand trucks and moved manually from the Process Weigh Room over rough floors through the Rolling Room to the Annealing Room. Heavy physical exertion was required and there was danger of accident to the man hauling the load and to others in the busy rolling room area. Rough floors, which could not be repaired without extended shut-down of rolling operations, made conditions worse. Thirty-six new skids of special size for accommodating 4 tote boxes, were purchased. These skids are loaded with tote boxes of blanks and moved by power lift truck to the Annealing Room. This eliminates manual pushing and pulling and also permits full control of the load in motion at all times. Tote boxes transferred from San Francisco are used on this job. An important benefit derived is improved safety conditions. Faster handling and better short time storage facilities have also resulted.		October 1957	Jan. 1958

REPORT ON MANAGEMENT ACTIONS PRESENTLY UNDERWAY
OR SCHEDULED FOR ACTION

Bureau or Office U. S. MINT - DENVER, COLORADO		COINING DIVISION		Date SEPTEMBER 30, 1957	
Action Number	Brief Title and Description of Surveys, Studies or Other Management Actions	Tentative Dates			
		Start	Finish		
6-27	Monetary savings are difficult to detail but are expected to be about \$1,000.00 annually. Improve handling of coinage ingots between the Ingot Melting Room and the Rolling Room. <u>Action Taken:</u> Formerly the ingots from the Melting Room were handled with hand trucks, 6 ingots being loaded on a truck. The breakdown mill crew transports all ingots from the ingot melting room on the second floor via freight elevator to the breakdown mill on the first floor. Heavy manual effort is required to move the ingots in this way and rough floors are a source of trouble and a safety threat. Among the items of equipment transferred from San Francisco were electric low-lift trucks and skids. Such of this equipment as was needed was put to use to replace the hand trucks in transporting ingots from the Melting Room to the breakdown mill. The skids are loaded with 12 ingots instead of 6, thus reducing the number of loads to be handled by 50% and eliminating manual pushing and pulling. Time is saved, floor congestion relieved and safety conditions improved. It is estimated that a saving of at least \$1,000.00 annually will be effected by this improvement.	October 1957	June 1958		

REPORT ON MANAGEMENT ACTIONS PRESENTLY UNDERWAY
OR SCHEDULED FOR ACTION

OCT 8 - 1957

Bureau or Office		Date	
U. S. Mint - Denver, Colorado		CASH & DEPOSITS DIV.	
		SEPTEMBER 30, 1957	
Action Number	Brief Title and Description of Surveys, Studies or Other Management Actions	Tentative Dates	
		Start	Finish
0-3	G.S.A. project remodeling elevator servicing main vault system. <u>Action Taken:</u> Enlarging of the floor space, for greater accommodation of equipment and safer operation, remains to be done.	Unknown	
3-16	Remodeling "I" Vault, whereby coin may be handled on pallets and shorten the distance between entrance to this vault and the loading dock, requiring the installation of a new door at the east end of vault and removing inner partitions, and the substitution of sliding doors for present doors. <u>Action Taken:</u> Some preliminary work has been done by the G.S.A. in cutting an opening for the new door. It is hoped that this project will be pushed to completion.	August 1957	December 1957
4-19	Remodeling a second basement window for simultaneous loading of coin into more than one vehicle at one time. <u>Action Taken:</u> To utilize to the fullest extent possible the advantages of a second window, it will be necessary to purchase a conveyor. Our request for funds to purchase a conveyor has been denied for the present.	Unknown	
5-20	Trading the present Yale Fork-Lift in on a Lewis-Shepard so that two lifts will be able to reach the same height, presently impossible, or acquiring a Lewis-Shepard Lift and transferring the present Yale lift to another division. <u>Action Taken:</u> This matter is pending, no action having been taken due to shortage of equipment funds.	Unknown	
7-1	Present processing of uncurrent coin requires pushing the coins onto a belt and leveling them by hand. Two Syntro Vibra Flor Feeders have been requested to expedite this operation. <u>Action Taken:</u> Purchase of this equipment has been deferred due to shortage of equipment funds.	Unknown	

Exhibit B

Bureau or Office		Date	
UNITED STATES MINT - DENVER, COLORADO BUILDING & MECHANICAL DIVISION		SEPTEMBER 30, 1957	
Action Number	Brief Title and Description of Surveys, Studies or Other Management Actions	Tentative Dates	
		Start	Finish
6-6	Purchase and install high pressure turbine blowers on the gas-fired melting furnace in the Deposit-Refinery and Ingot Melt Rooms. <u>Action Taken:</u> Awaiting availability of funds.	Unknown	
6-8	Install watt-hour meters on all electrical circuits. <u>Action Taken:</u> Awaiting availability of funds.	Unknown	
7-1	Replace 75 horsepower blower motor with 25 horsepower Simplex blower. <u>Action Taken:</u> Awaiting availability of funds.	Unknown	
7-2	Install additional heat exchangers on roll cooling water system to reduce temperature of water. <u>Action Taken:</u> Awaiting availability of funds.	Unknown	
All of the above projects, when completed, will reduce our power, light and gas bills considerably.			

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REPORT ON MANAGEMENT ACTIONS PRESENTLY UNDERWAY
OR SCHEDULED FOR ACTION

Bureau or Office		Date	
UNITED STATES MINT, DENVER, COLORADO		SEPTEMBER 30, 1957	
Action Number	Brief Title and Description of Surveys, Studies or Other Management Actions	Tentative Dates	
		Start	Finish
	<u>GENERAL MANAGEMENT IMPROVEMENT PROBLEMS</u>		
2-2	Install new passenger elevator in rear main hall. <u>Action Taken:</u> Public Buildings Services has let a contract for installing an elevator. We have been informed by General Services Administration that work on installation will start about October 1, with completion about May, 1958.	October 1957	May 1958
3-4	Rehabilitation of U. S. Seal in lobby of building. <u>Action Taken:</u> Public Buildings Service will complete this project as soon as services of a competent firm can be secured. The seal is completely worn down and obliterated.	Unknown	
7-3	Resurface passageway floors in Coining Division. <u>Action Taken:</u> At the present time, a new hard surfacing is being tried on the floors of the Coining Division. Public Buildings Service will take no further action until the results of this new surfacing are known. This project will be dropped from future reports.	November 1957	

REPORT ON COMPLETED MANAGEMENT ACTIONS

Bureau or Office		Quarter Ending	
UNITED STATES MINT, DENVER, COLORADO		SEPTEMBER 30, 1957	
Action Number	Brief Title and Description of Surveys, Studies or Other Management Actions	Estimated Annual	
		Recurring Savings	
		Manpower	Monetary
	<u>GENERAL MANAGEMENT IMPROVEMENT PROBLEMS</u>		
2-3	Install additional toilets on the mezzanine floor. <u>Action Taken:</u> This project was completed in September.		
5-1	Installation of additional security measures for protection of Mint property. <u>Action Taken:</u> Work on surfacing and fencing the property, as well as establishing a new alley, was completed in August.		
No annual savings are involved in the above projects. Action 2-3 is a project for the convenience of visitors. Action 5-1 is an additional project for the security of the building and grounds.			

